

Work Order ID 54668

December 16, 2009 8:35:06 AM



Page 1

Item ID: D3293-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 16/12/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 16/12/2009 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan:

RL

Date: 09-12-16

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3293

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3293

Dwg Rev: A

Prog Rev: A

2-

Deburr if necessary

2674-080

B 10-1-28



110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 10-1-28

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

=> 5 10/12/28



Pho ->

W/O: 54668		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/01/26	#120	Took Qty x1 For inspection template	S	10/06/26	1		 10/01/26

Part No: D3293-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54668

December 16, 2009 8:35:06 AM



Page 2

Item ID: D3293-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 16/12/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 16/12/2009 Required Qty: 8.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

1- Deburr

0.00

0.00

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QS1005 4.1

Memo

0.00

0.00

BR 10-02-01

15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54668

December 16, 2009 8:35:06 AM



Item ID: D3293-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 16/12/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 16/12/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Black Sandtex(Ref:4.3.5.7) per QS1005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

1:30pm

OVEN TEMPERATURE:

2:00pm FINISH TIME:

320°F

⇒ JEL 10/04/02

15

φ

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BK 10-02-2

(15) φ

180

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

211

10-2-4

el

15x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54668

December 16, 2009 8:35:06 AM



Page 4

Item ID: D3293-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 16/12/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 16/12/2009 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/04 *[Signature]*

MF 10-2-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 16, 2009 8:35:11 AM

Page 1

Work Order ID: 54668



Parent Item: D3293-1



Parent Item Name: Doubler

Start Date: 16/12/2009

Required Date: 16/12/2009

Comments:

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Big Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M2024T3S.080

Purchased

No

100

sf

169.2618

15.3802

31.



13 10-1-28

2024-T3 .080 sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

169.26185

104921

3

105411

17

107460

4.36

110908

29.52205

112331

105.8798

15628

6

17695

1.5

18481

2

113796

113796



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	541668
Description: Doubler		Part Number:	D3293-1
Inspection Dwg: D3293 Rev: A			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



X

First Article

1

Prototype

[illegible]

Measured by: 	Audited by: 	Prototype Approval:	N/A
Date: 10-1-23	Date: 10/6/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	KJ/JLM	
B	08.10.09	0.080 dimension added	KJ/DD	

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED
SUBJECT TO
WITHOUT NOTICE
WORK ORDER
NO. 54668
REV 04-12-16



DESIGN	DRAWN BY	DART AEROSPACE LTD
14	14	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
[Signature]	[Signature]	D3293
DATE	TITLE	REV. A
04.06.28	DOUBLER	SHEET 1 OF 1
A	04.06.28	NEW ISSUE
		SCALE 1:3

D3293-1 DOUBLER

MAKE PER DRAWING FILE "D3293-A1.DWG"

CHECK PER TEMPLATE D3293-1T1

DIMENSIONS SHOWN FOR REFERENCE ONLY

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.080 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER

DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12

DETAIL A SCALE 2:3

